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D4776-3**Job Sheet 187981****Part No:** D4776-3**Job Qty:** 10 ea**Part Name:** Skidtube Clevis**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 12/29/18**Job Tracking No:****Due Date:** 12/30/18**Created By:** Linda Lacelle**Type:** SOLD**Description:**

Note: DWG D4776 REV:E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/30/18	12/30/18	0.00	0.00	Start Up Machining-3		A.E. 18-12-30
100	Bandsaw	10 pcs	12/30/18	12/30/18	0.00	0.18	Bandsaw1		A.E. 18-12-30
110	CNC Vertical Machining	10 pcs	12/30/18	12/30/18	0.26	8.70	HAAS1-5		A.E. 18-12-30
120	QC	10 pcs	12/30/18	12/30/18	0.00	0.00	QC2 Machining-3		A.E. 18-12-30
130	QC	10 pcs	12/30/18	12/30/18	0.00	0.00	QC8 Machining-3		A.E. 18-12-30
140	HandFinish	10 pcs	12/30/18	12/30/18	0.00	0.26	HandFinish1		19-01-03
150	QC	10 pcs	12/30/18	12/30/18	0.00	0.00	QC7-4		BEB 19-01-03
160	Powdercoat	10 pcs	12/30/18	12/30/18	0.00	0.12	Powdercoat1		JAN 03 2019
170	QC	10 pcs	12/30/18	12/30/18	0.00	0.00	QC3		BEB 19-01-03
180	Packaging	10 pcs	12/30/18	12/30/18	0.00	0.00	Packaging3-2		JAN 04 2019
190	QC21-SA	10 Ea	12/30/18	12/30/18	0.00	0.00	QC21		JAN 07 2019

Part Op 100 - Cut Blank at 4.400" 4.625"

Descriptions: 110 - 1-Machine per folio FB168 DWG REV: FOLIO REV: 2- deburr and break all sharp edges

M38951 160 - START TIME: 4:30 OVEN TEMPERATURE: 320° FINISH TIME: 5:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50 2.50x1.50	3.8600 ft (.386 ea)	90-Start up Operation	51244631 → 2.840ft → 5052630 → 1.020ft

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	4	0	0



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Container No: S141723



Part: D4776-3

Job No: 187981

Serial No/Batch: S141723

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/03/19

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches $\pm$ 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches $\pm$ 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches $\pm$ 0.010	1.698 1.678		
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		
5	Skidtube Clevis	0.510Inches $\pm$ 0.010 - 0.000	0.520 0.510		
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053		
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350		
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		
9	Skidtube Clevis	1.000Inches $\pm$ 0.030	1.030 0.970		
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 - 0.001	0.490 0.483	Diameter	
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		
12	Skidtube Clevis	0.550Inches $\pm$ 0.030	0.580 0.520		
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140		
14	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100		
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678		
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 - 0.001	0.403 0.396	Diameter	
17	Skidtube Clevis	1.813Inches $\pm$ 0.010	1.823 1.803		
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius	
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius	
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115		
22	Skidtube Clevis	0.380Inches $\pm$ 0.030	0.410 0.350		
23	Skidtube Clevis	0.750Inches $\pm$ 0.030	0.780 0.720		
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	

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